

142471

Wednesday, March 09, 2016 2:51:23 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/6/2016 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 4/15/2016 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: Process Plan: MCS Date: MAR 10 2018

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

SPC (Y/N):

Date:

Stop *NR2*

Draw Nbr	Revision Nbr	
D3884	C	

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.19

HAAS CNC vertical machine #1

Program Batch No. 142 471

Double check by: 

1-Machine Step No 1 per Folio FA819 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA819 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA819 and inspect per Dimension Sheets

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			

Wednesday, March 09, 2016 2:51:23 PM

Item ID: D3884-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Saddle, Inboard RH

Stop *NS2*

Start Date: 4/6/2016 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 4/15/2016 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

120

QC8- Inspect parts - second check

0.00

120

OC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.02

Hand Finishing

12x d all 16/64/25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 142471

142471

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Wednesday, March 09, 2016 2:51:23 PM

Item ID: D3884-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Inboard RH
 Start Date: 4/6/2016 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 4/15/2016 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140									
Powdercoat	Memo	0.01							
Powder Coating	***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED ON DWG (SEE NOTE 2)*** <i>M 134631</i> ***DO NOT MASK INSIDE FLANGE SURFACE*** START TIME: <i>9.05</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>9.35</i>								<i>12</i> <i>1605-17</i> <i>233</i>
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									<i>(12)</i> <i>DAS</i> <i>38</i> <i>9-88</i>

MAY 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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Work Order ID 142471

Wednesday, March 09, 2016 2:51:23 PM

142471

Page 4

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Revision ID: Stop ***NS2***
Item Name: Saddle, Inboard RH
Start Date: 4/6/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 4/15/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>SH404</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.02							
Quality Control									

12 MAY 17 2016 Das

16/5/18 HA

ML5 MAY 18 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

Picklist Print

Wednesday, March 09, 2016 2:51:23 PM

Page 1

Work Order ID: 142471

142471

Parent Item: D3884-2

D3884-2

Parent Item Name: Saddle, Inboard RH

Start Date: 4/6/2016

Required Date: 4/15/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC
15.05.20 remove inside powdercoat DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-017		Manufactured	No				Each	33.0000		12			
-----------	--	--------------	----	--	--	--	------	---------	--	----	--	--	--

D6101-017

Saddle Billet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT044	9	
133963	5	
135525	4	
MAT046	24	
137532	12	
138595	12	

142580

5

P16-04-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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DART AEROSPACE LTD		Work Order: 142471
Description: Saddle, Inboard, RH		Part Number: D3884-2
Inspection Dwg: D3884	Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658	.5115	.646	.646	.646	.646		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.257	.257	.257	.257		
F	0.605	0.625	H865	.64	.615	.614	.615		
G	1.120	1.130		1.105	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.004	2.007	2.005	2.005		
J	0.140	0.175		.143	.142	.143	.143		
K	1.265	1.285		1.269	1.272	1.270	1.270		
L	0.115	0.135		.125	.127	.127	.127		
M	0.240	0.260		.250	.252	.252	.269		
N	0.110	0.140		.140	.140	.136	.140		
O	0.240	0.260		.250	.253	.253	.253		
P	2.826	2.886		2.858	2.856	2.856	2.856		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.152	.153	.152	.152		
S	0.720	0.780		.755	.755	.755	.755		
T	1.220	1.280		1.256	1.256	1.256	1.256		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.001	6.001	6.001	6.001		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510	.3435	.502	.502	.501	.500		
Y	0.020	0.040		.032	.032	.032	.032		
Z	0.313	0.318		.313	.313	.313	.313		
AA	0.760	0.765		.761	.761	.761	.761		
AB	0.215	0.220		.218	.219	.219	.219		
AC	0.316	0.321		.316	.316	.316	.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010	.842	1.000	1.000	1.000	1.000		
AF									
Accept/Reject									

Measured by:	P16-04-21
Date:	

Audited by:	FA
Date:	16/04/22

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 142471
Description: Saddle, Inboard, RH		Part Number: D3884-2
Inspection Dwg: D3884	Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	37	48	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658	545	.646	.646	.647	.648		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.257	.257	.257	.257		
F	0.605	0.625	785	.614	.614	.614	.614		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.003	2.003	2.003	2.004		
J	0.140	0.175		.143	.143	.143	.144		
K	1.265	1.285		1.271	1.260	1.268	1.269		
L	0.115	0.135		.126	.125	.124	.125		
M	0.240	0.260		.252	.250	.249	.250		
N	0.110	0.140		.139	.139	.140	.139		
O	0.240	0.260		.248	.250	.250	.250		
P	2.826	2.886		2.856	2.855	2.856	2.855		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.152	.153	.152	.152		
S	0.720	0.780		.760	.760	.760	.760		
T	1.220	1.280		1.256	1.256	1.256	1.256		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.001	6.001	6.001	6.001		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510	845	.503	.5015	.5005	.501		
Y	0.020	0.040		.032	.032	.032	.032		
Z	0.313	0.318		.313	.313	.313	.313		
AA	0.760	0.765		.760	.760	.760	.760		
AB	0.215	0.220		.219	.219	.217	.218		
AC	0.316	0.321		.316	.316	.316	.316		
AD	1.745	1.755		1.750	1.750	1.750	1.75		
AE	0.990	1.010	442	.9995	1.0005	1.001	1.002		
AF									
Accept/Reject									

Measured by:	P 14-04-22
Date:	

Audited by:	F.K
Date:	16/04/22

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	142471
Description: Saddle, Inboard, RH		Part Number:	D3884-2
Inspection Dwg: D3884	Rev. C	Page 1 of 1	

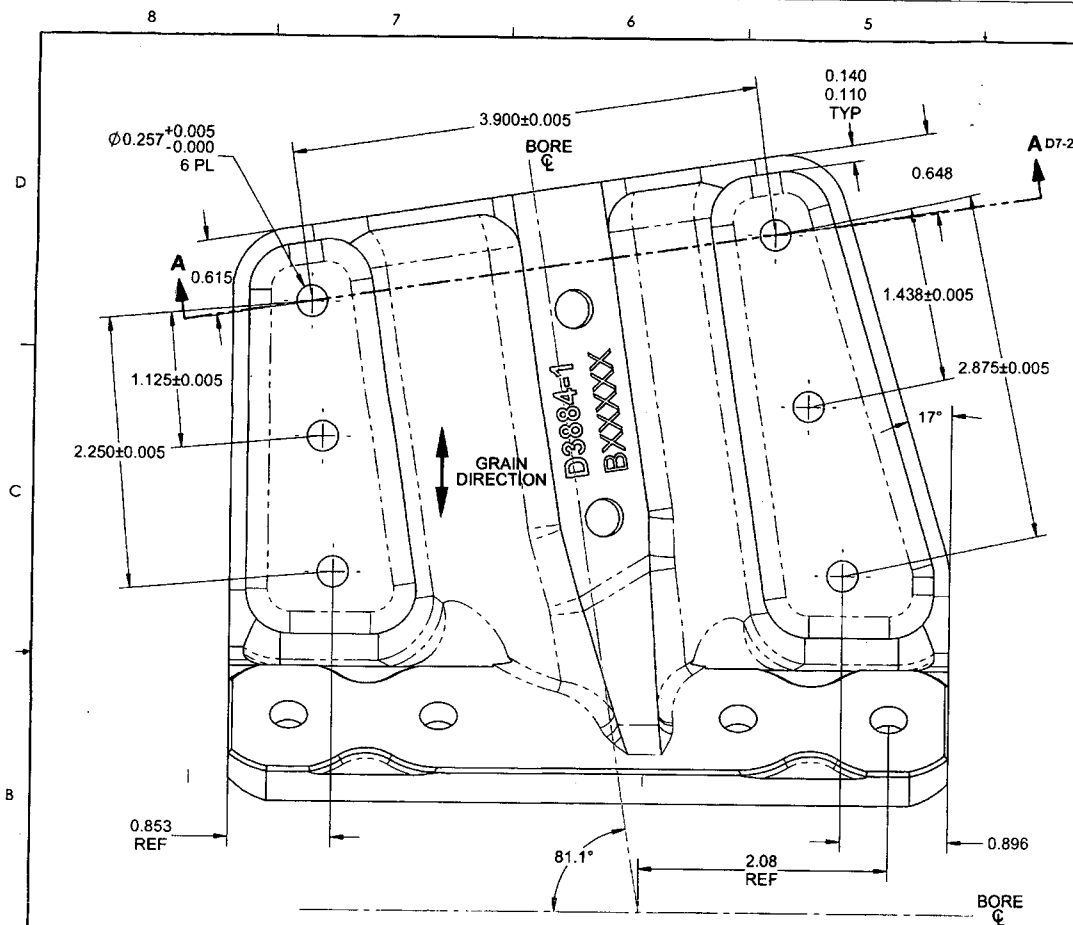
Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				A9	A10	A11	A12		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658	STPS	.6465	.6465	.646	.6465		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.257	.257	.257	.257		
F	0.605	0.625	H615	.615	.615	.635	.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.004	2.003	2.003	2.003		
J	0.140	0.175		.144	.143	.143	.143		
K	1.265	1.285		1.269	1.268	1.268	1.268		
L	0.115	0.135		.125	.125	.125	.125		
M	0.240	0.260		.250	.250	.250	.250		
N	0.110	0.140		.140	.137	.140	.140		
O	0.240	0.260		.251	.252	.252	.252		
P	2.826	2.886		2.856	2.856	2.855	2.856		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.150	.150	.150	.150		
S	0.720	0.780		.760	.760	.760	.760		
T	1.220	1.280		1.260	1.260	1.260	1.260		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.001	6.001	6.001	6.001		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510	3485	.5015	.501	.5005	.4995		
Y	0.020	0.040		.032	.032	.032	.032		
Z	0.313	0.318		.313	.313	.313	.313		
AA	0.760	0.765		.760	.760	.760	.760		
AB	0.215	0.220		.219	.219	.215	.215		
AC	0.316	0.321		.316	.316	.316	.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010	842	1.0005	1.0015	1.000	1.001		
AF									
Accept/Reject									

Measured by:	16-04-22
Date:	

Audited by:	FK
Date:	16/04/22

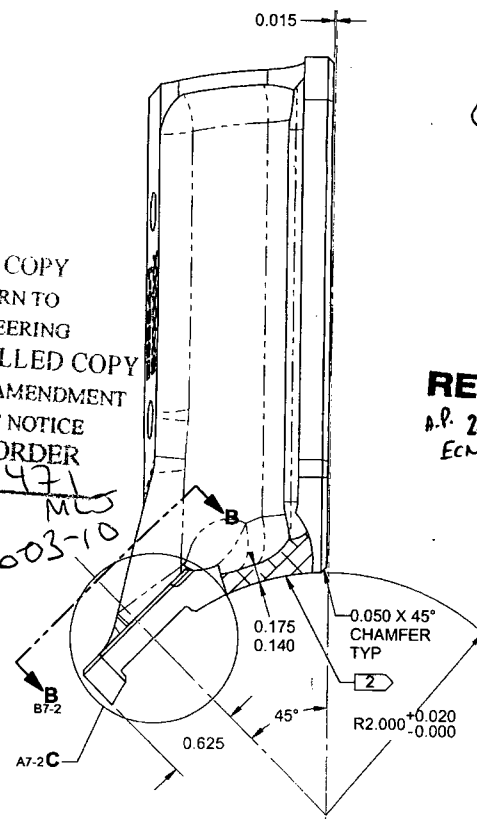
Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	



D3884-1 SADDLE, INBOARD LH

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1603-10



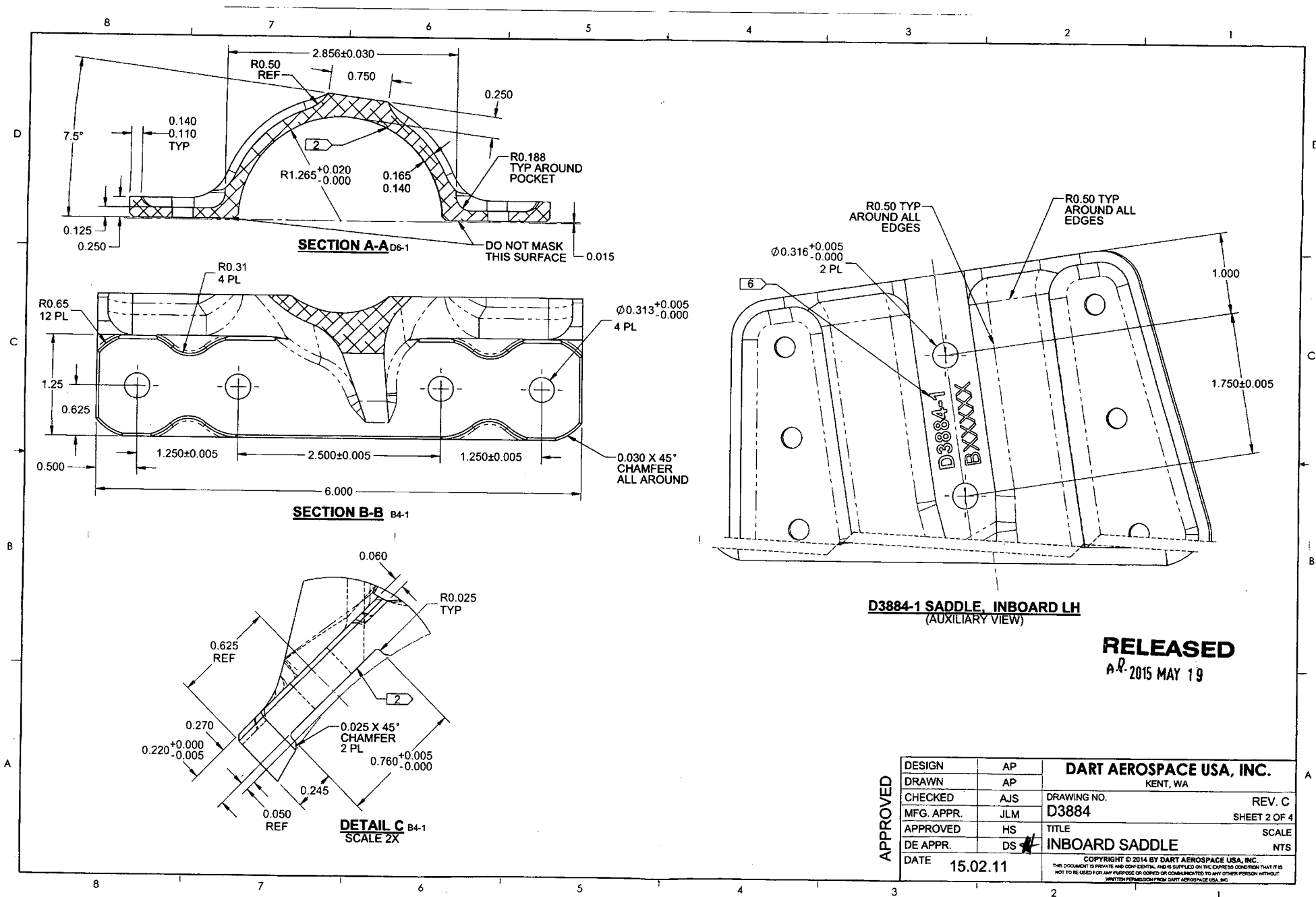
RELEASED
A.P. 2015 MAY 19
ECN 15-575

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3884-1-REVC.SLDPRIT"

C	GENERAL REDRAW & REMOVED UNNECESSARY DIMS. ADDED NOTE 9, REMOVED POWDER COAT FROM INSIDE SURFACE OF D3884-1/2, ADDED D3884-2 TO SHT 3 & 4.	AP	15.02.11
B	D6101-017 WAS D6102-017, ZN A6-1; ADD NOTE ZN C4-2; ADD R0.031 ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.165 ZN B7-1; ADD 0.615 ZN C6-1; ADD 0.648 ZN C4-1; ADD 0.250 ZN D6-2; ADD 0.060 ZN C2-2; 0.75 WAS 0.65 ZN D7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO. D3884	
MFG. APPR.	JLM	REV. C	
APPROVED	HS	TITLE INBOARD SADDLE	
DE APPR.	DS	SCALE NTS	
DATE	15.02.11	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

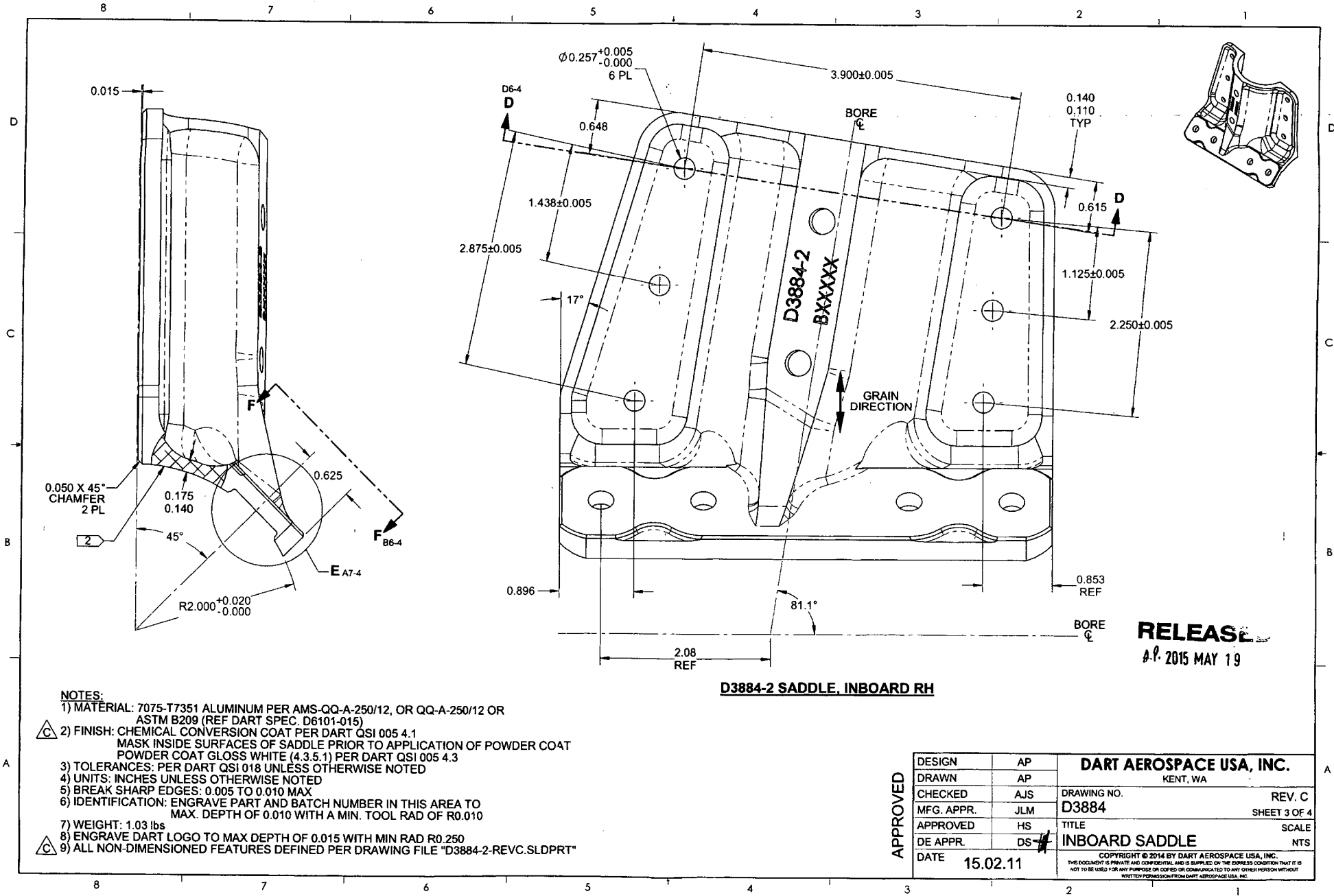
APPROVED



D3884-1 SADDLE, INBOARD LH
(AUXILIARY VIEW)

RELEASED
AR-2015 MAY 19

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D3884	SHEET 2 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	INBOARD SADDLE	NTS
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A.P. 2015 MAY 19

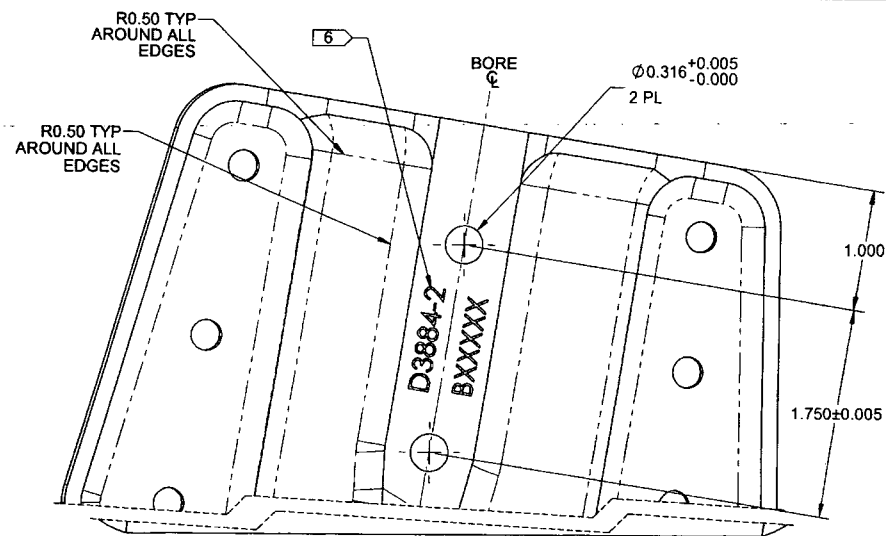
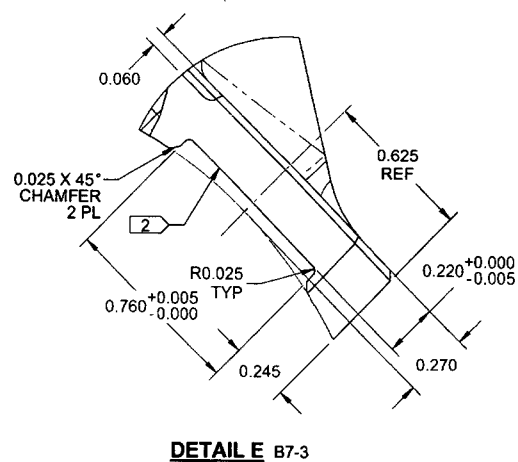
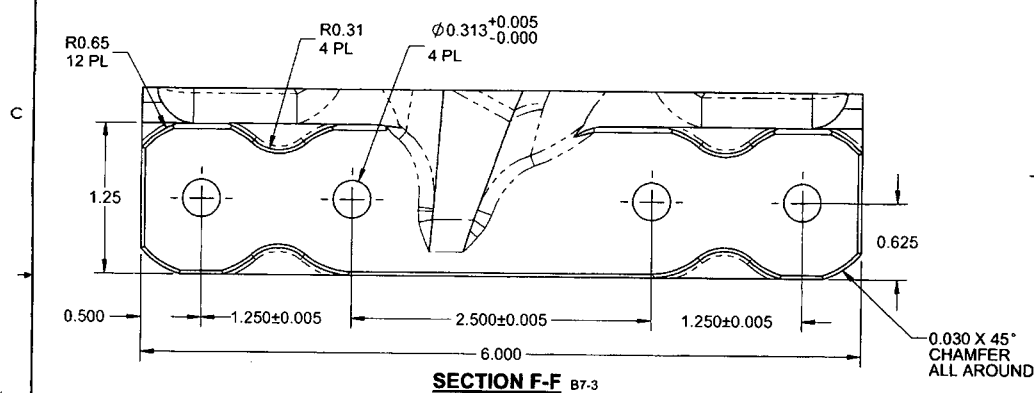
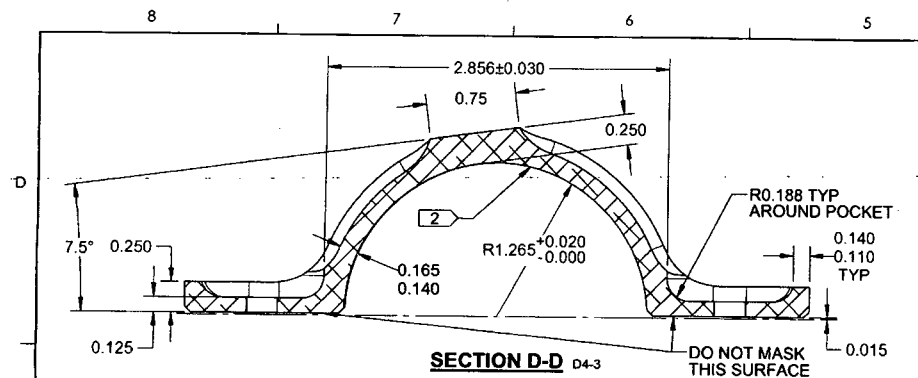
D3884-2 SADDLE, INBOARD RH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3884-2-REVC.SLDPRT"

APPROVED

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3884	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	INBOARD SADDLE	NTS
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APR 2015 MAY 19

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	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D3884	SHEET 4 OF 4
	APPROVED	HS	TITLE	SCALE
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